

156858

Wednesday, February 08, 2017 9:11:18 AM

N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

Start Date: 2/3/2017 **Start Qty:** 10.00

Required Date: 2/8/2017 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan: Date: FEB 06 2017

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

100	FLOW WATER JET	0.00		
100				
Waterjet	Memo	0.00	(11)	02/17/02/11
FLOW CNC Waterjet	1-Cut as per Dwg D2232 Dwg Rev: 1 Prog Rev: 1 2-Deburr if necessary			
110	QC2- Inspect parts off machine FAI/FAIB	0.00		
110				
QC	Memo	0.02	(11)	02/17/02/11
Quality Control				
120	QC8- Inspect parts - second check	0.00		
120				
QC	Memo	0.03	11	DAS 38 0.00 FEB 13 2017
Quality Control				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
QC / QA Coordinator Approval 									

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 156858***156858***

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Wednesday, February 08, 2017 9:11:18 AM

Item ID: D2232-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Hinge

Start Date: 2/3/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/8/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130	Small Fab	0.00							
Small Fab	Memo Debur								
	<i>N/A</i> <i>DAS 38 9-89</i>								
140	Identify as per dwg & Stock Location: _____	0.00							
140	Packaging	0.02							
Packaging	Memo *****STOCK IN BASKET CELL***** LOCATION : WA004								
	<i>11</i> <i>DAS 6 9-89</i> <i>FEB 14 2017</i>								
150	QC21- Final Inspection - Work Order Release	0.00							
150	QC	0.17							
Quality Control	Memo								
	<i>DAS 21 9-89</i> <i>FEB 15 2017</i> <i>ME</i> <i>17-2-14</i>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, February 08, 2017 9:11:17 AM

Page 1
1

Work Order ID: 156858

156858

Parent Item: D2232-3

D2232-3

Parent Item Name: Basket Hinge

Start Date: 2/3/2017

Required Date: 2/8/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B01.06.07Now laser cutEC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	62.4100	0.0694	0.730526			

M304S11GA

304/316 0.125 Sheet

02/17/02/11

Location

Loc Qty

Loc Code

MAT020

62.40998

M129545

0.00109

M134604

1.3

M135355

2.80889

M136327

26.3

M136687

32

.9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

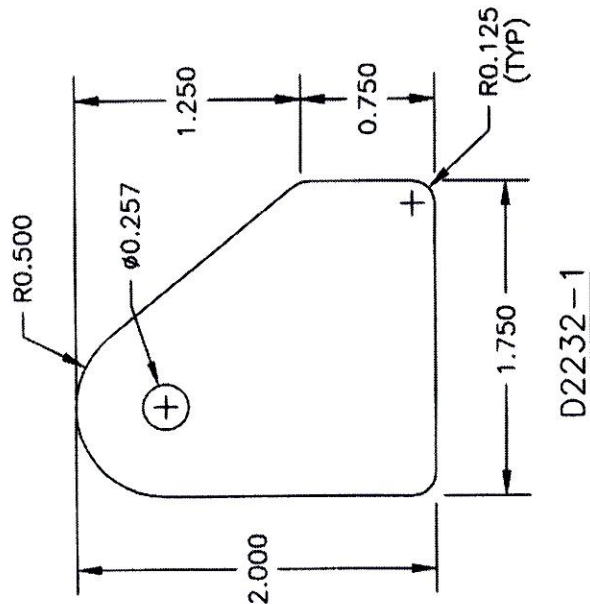
Work Order update only ☐

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Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

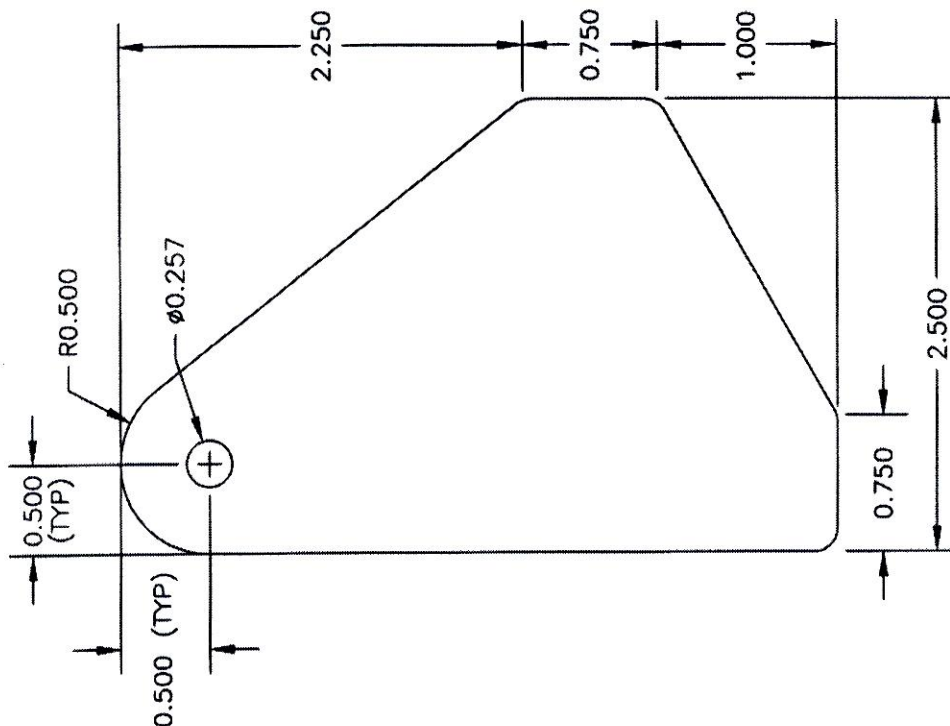


DESIGN	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>WJ</i>	APPROVED <i>KE</i>	DRAWING NO. D2232	REV. C SHEET 1 OF 2
DATE 98.04.28	TITLE BASKET HINGE		SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	

RELEASED
98.05.05 KE



SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 17685845
170209

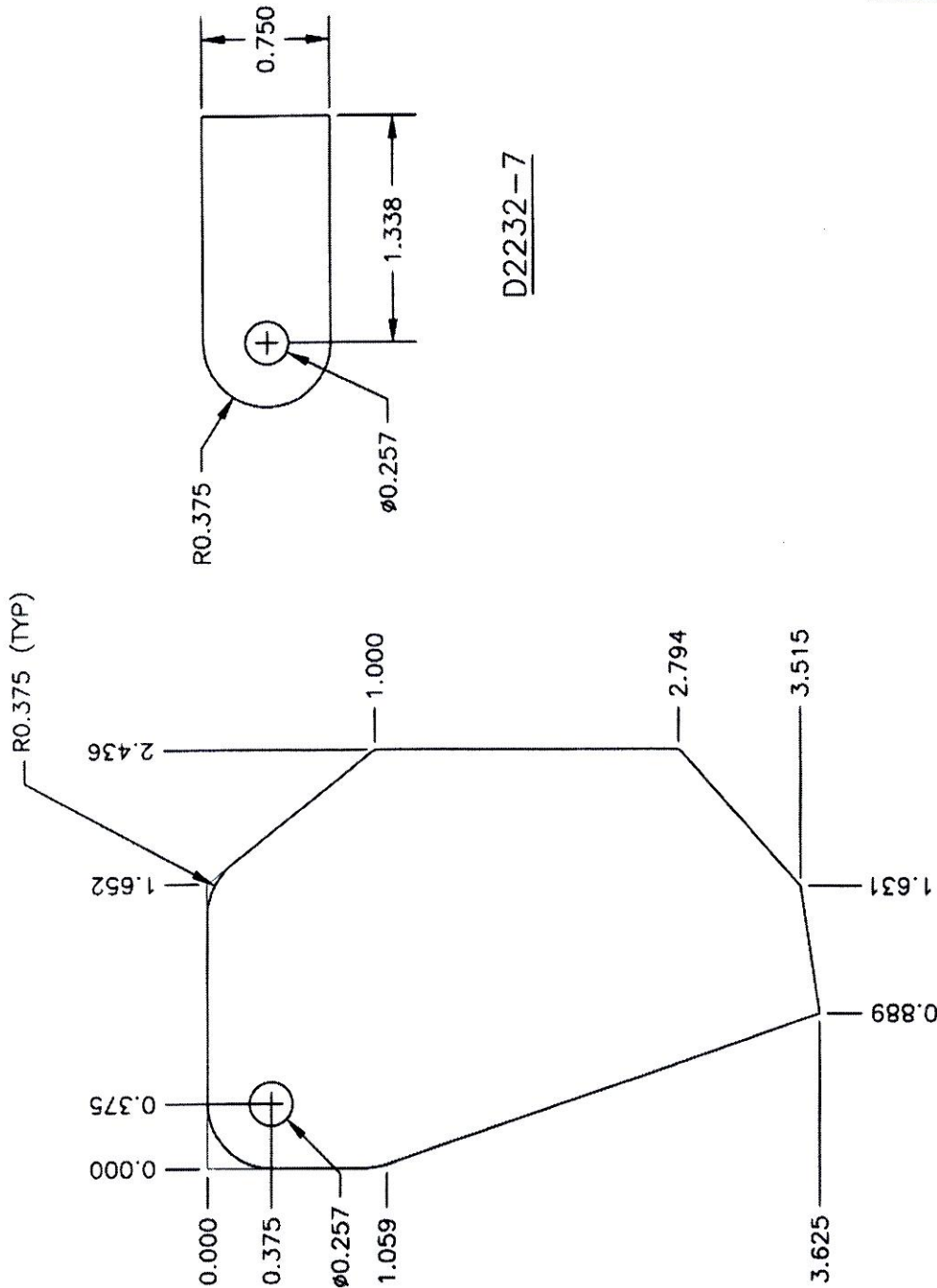


MATERIAL: AISI 304/316 SS 0.125 THICK



DESIGN <i>[Signature]</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2232	REV. C SHEET 2 OF 2
DATE 98.04.28	TITLE BASKET HINGE		SCALE 1:1

RELEASED
98.05.05 KE



D2232-7

D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK